

Work Order ID 62767

Thursday, October 07, 2010 3:13:49 PM



Page 1

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 10/7/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: 14Date: 10-10-07 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-541 CHG003

N/A AD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start
StopSequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and QSI004

AR Aluminum Rod Batch: M111385/m115778

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.
Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DFB 10-10-13

BE 10/10/14

SA 10-10-18

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Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

130

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

0

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 ☐ 11/15/14 ☐

Sikaflex expire date: ☐ 01/2011 ☐

Start: ☐ 10/10/20 ☐ Time: ☐ 2:00 ☐

Finish: ☐ 10/10/20 ☐ Time: ☐ 8:30am ☐

(Adhere for 12 hours)

Handwritten: DP 10-10-19
BC 10/10/20

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Handwritten: S 10/10/20

Handwritten: (X)

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

1 2 BE10/11/01

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

h = 3.00"

L = 4.8"

S 10/14/02

70

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W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 Skidtubes	Skidtubes	0.00				1	0	BE 10/11/02	
Skidtubes	Memo 1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod A/R <input type="checkbox"/> Aluminum Rod <u>M11K385</u>	0.00							
	3-Grind cross bolt welds flush as per Dwg D3274.								
	4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.								
200 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo <i>Skid tubes</i>	0.00							

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210  QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		8 duloz		(X)			
220  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch	0.00 0.00		=) M 10/11/03		1	Ø		
230  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 2:00 OVEN TEMPERATURE: 300 FINISH TIME: 2:30.	0.00 0.00		M 11/5/09		1		10-11-3.	

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				21	0		
250 	HandFinishing	0.00							
HandFinish Hand Finishing	Memo 1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. A/R <input type="checkbox"/> N/A <input type="checkbox"/> LPS-3 <input type="checkbox"/> 11109956 2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> 11115114 Sikaflex expire date: <input type="checkbox"/> 11101	0.00				1	0		
260 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo Inspect Nut Plate & Inserts	0.00				40			

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270 HandFinish Hand Finishing	HAND FINISHING RESOURCE #1 Memo 1-Install wearpads & gaskets as per Dwg D3274. 2-Install ring as per Dwg D3274 A/R <input type="checkbox"/> Sikaflex-291 <input checked="" type="checkbox"/> 11/15/10 Sikaflex expire date: <input type="checkbox"/> 11/01 3-Inspect for foreign objects as per QSI 024 4-Spray inside of tube on both sides of web with LPS-3 A/R LPS-3 Batch: 10/12 5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive. A/R <input type="checkbox"/> Sikaflex-291 <input checked="" type="checkbox"/> 11/15/10 Sikaflex expire date: <input type="checkbox"/> 11/01	0.00 0.00	270	10/14/10		1	0		
280 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8/10/10					

70

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290 	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									
300 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

C 60/414

10/11/05

ME

10-11-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Parent Item Name: Replacement Skidtube


Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-190  Extrusion Round 3" 206		Manufactured	No			110	Each	73.0000	1	1			

Location

Loc Qty

Loc Code

LG

73

47575

25

59874

48

DP 10-10-13

D3285-1  Cap		Manufactured	No			110	Each	141.0000	1	1			
--	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

Location

Loc Qty

Loc Code

LG

141

52511

74

52647

67

BE 10/10/14

D3282-041  Float Web (206L/407)		Manufactured	No			150	Each	2.0000	1	1			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location

Loc Qty

Loc Code

LG

2

59886

2

B 62947 1 BE 10/10/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190 Each

65.0000

1 1



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

65

58545

2

60652

4

61496

59

B62889 12 BE10/11/02

D3275-1

Manufactured No

190 Each

216.0000

12 12



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

216

53453

8

61646

102

62399

106

12 BE10/11/02

CR3212-4-03

Purchased No

250 Each

1,888.000

2 2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

1888

111359

5

112314

2

114436

448

114450

71

114859

1362

yz

D3415-041

Manufactured No

250 Each

52.0000

1 1



Nut Plate

Location

Loc Qty

Loc Code

ST056

52

33842

52

xl

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Shop Packet Print

Page 2

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Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

250

Each

446.0000

2

2



Handwritten: 10/14/10

Cherry Rivet

Location

Loc Qty

Loc Code

ST311

446

112314

4

113539

44

113973

398

Handwritten: x2

ALS4-1032-130

Purchased

No

250

Each

1,147.000

78

78



Handwritten: 10/11/10

Insert

Location

Loc Qty

Loc Code

PKG11

1098

114723

1098

ST282

10

110511

10

ST381

39

114654

39

Handwritten: M115911

Handwritten: x78

D3536-15

Manufactured

No

270

Each

21.0000

1

1



Handwritten: 10/11/10

Gasket

Location

Loc Qty

Loc Code

FP

9

56055

1

60875

8

FP11

12

59238

1

62459

11

Handwritten: x1

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Shop Packet Print

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Required Date: 10/15/2010

Start Qty: 1.00




Required Qty: 1.00

D3536-23 Manufactured No 270 Each 8.0000 1 1
   all 10/11/04
 Gasket




Location	Loc Qty	Loc Code
FP011	8	B03391
61237	8	

D3536-35 Manufactured No 270 Each 23.0000 1 1
   all 10/11/04
 Gasket

Location	Loc Qty	Loc Code
FP012	23	
58683	1	
61692	10	
<u>62462</u>	12	

D3536-39 Manufactured No 270 Each 12.0000 1 1
   all 10/11/04
 Gasket

Location	Loc Qty	Loc Code
FP12	12	
58215	1	
<u>58571</u>	11	

D3535-15 Manufactured No 270 Each 12.0000 1 1
   all 10/11/04
 Wearshoe

Location	Loc Qty	Loc Code
FP18	12	
61241	6	
<u>62241</u>	6	

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Page 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 62767

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 10/7/2010

Required Date: 10/15/2010



Start Qty: 1.00

Required Qty: 1.00

D3535-35	Manufactured	No	270	Each	8.0000	1	1
							<u>VI 10/11/04</u>
Wearshoe							



Location Loc Qty Loc Code

FP018	8	
60865	8	

D3535-39	Manufactured	No	270	Each	17.0000	1	1
							<u>VI 10/11/04</u>
Wearshoe							



Location Loc Qty Loc Code

FP18	17	
58214	1	
60233	16	

D3535-23	Manufactured	No	270	Each	19.0000	1	1
							<u>VI 10/11/04</u>
Wearshoe							

Location Loc Qty Loc Code

FP	7	
61830	7	
FP021	20	
60231	11	

D3537-3	Manufactured	No	270	Each	6.0000	1	1
							<u>VI 10/11/04</u>
Wearpad							

Location Loc Qty Loc Code

FP17	6	
60866	6	

B61674

VI

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 62767



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

270

Each

14.0000

9

9



Wearpad



10/15/10

Location

Loc Qty

Loc Code

FP
55465
FP017
61986
FP17
57713
60491
61640

1
1
6
6
7
3
3
1

B62661

89

AN960C10L

NAS1149C0332
R

Purchased

No

270

Each

29.0000

80

80



washer

1115832



10/15/10

Location

Loc Qty

Loc Code

ST245
107534

29
29

AN960C416

NAS1149C0463
R

Purchased

No

270

Each

100.0000

1

1



washer

1115358



10/15/10

Location

Loc Qty

Loc Code

ST346
100993

100
100

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 07, 2010 3:13:53 PM

Page 7

Work Order ID: 62767

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

270

Each

855.0000

2

2



Phenolic Washer



10/11/10

Location

Loc Qty

Loc Code

ST077

855

42329

150

52505

705

AN3C4A

Purchased

No

270

Each

1,650.000

80

80



BOLT



10/11/10

Location

Loc Qty

Loc Code

ST245

20

110139

20

ST303

42

115438

42

ST350

1588

114108

14

114416

12

114523

2

115300

560

115589

1000

AN4C5A

Purchased

No

270

Each

489.0000

1

1



BOLT



10/11/10

Location

Loc Qty

Loc Code

ST346

489

110552

4

112243

485

10/11/10

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Page 7

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 62767

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

44.0000

1

1



Aft Cap



JH 10/14/10

LocationLoc QtyLoc Code

FP-4

39

57332

39

fp5

1

61752

1

FP6

4

52663

4

X1

D3413-1

Manufactured No

270

Each

31.0000

1

1



Ring



JH 10/14/10

LocationLoc QtyLoc Code

ST473

31

51586

1

53446

15

61322

15

X1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DEO ATTACHED

DESIGN	CP	DRAWN BY	PH	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. D
				D3274	SHEET 1 OF 4
DATE				TITLE	
06.12.19				SKIDTUBE ASSEMBLY	
				SCALE	NTS
A	04.03.15		NEW ISSUE		
B	04.08.09		MOVE SADDLE HOLE: 42.14 WAS 42.76		
C	05.03.16		ADD -043; NEW INSERTS		
D	06.12.19		NEW INSERTS, SS WEARSHOE + GASKET		

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- ALL HOLES DRILLED ON CENTERLINES.
- BOND D3282-041 FLOAT WEB INTO D3274-1/3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- WELDING TO BE DONE PER DART QSI 004.
- FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

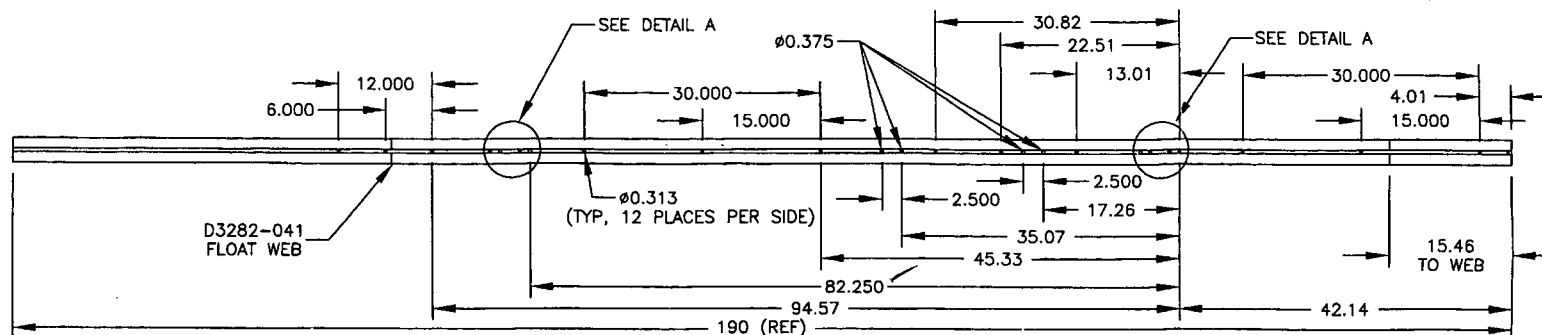
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

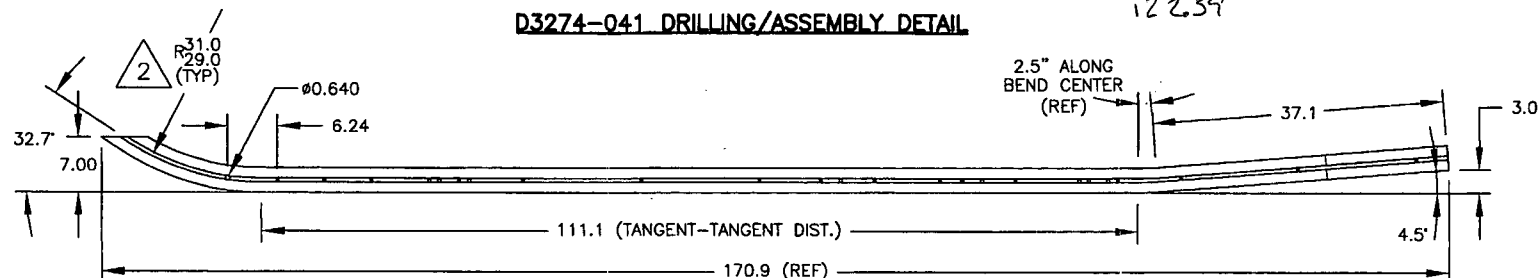
NOTE: Date & initial all entries

DEO ATTACHED

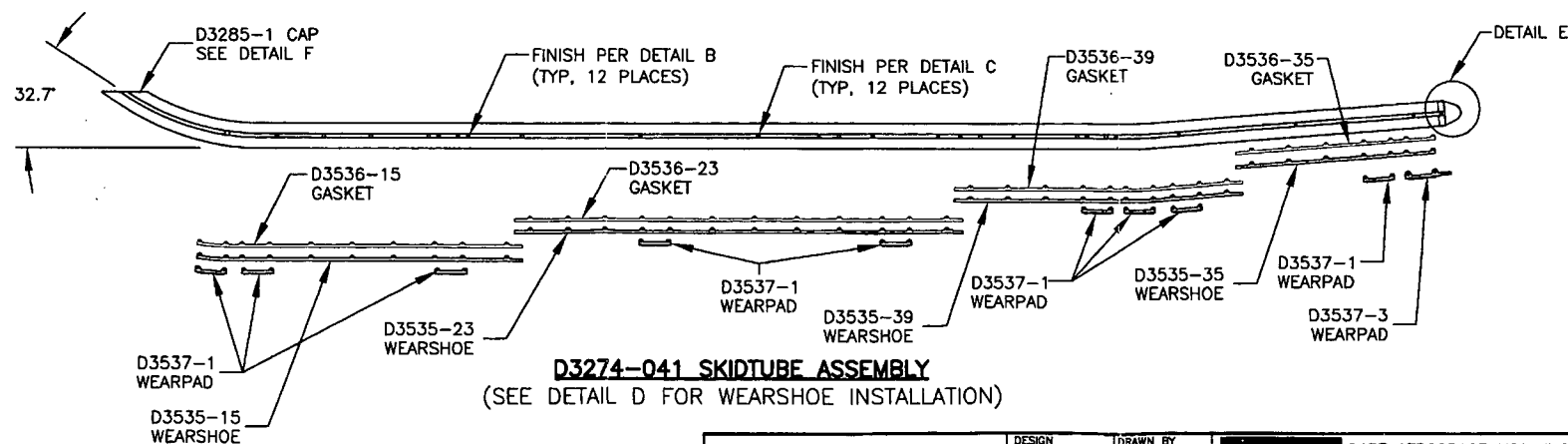
w/o 62747



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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CHECKED	CP	APPROVED	PH	DRAWING NO.	REV. D
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	SHEET 2 OF 4	SCALE
				1:15	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

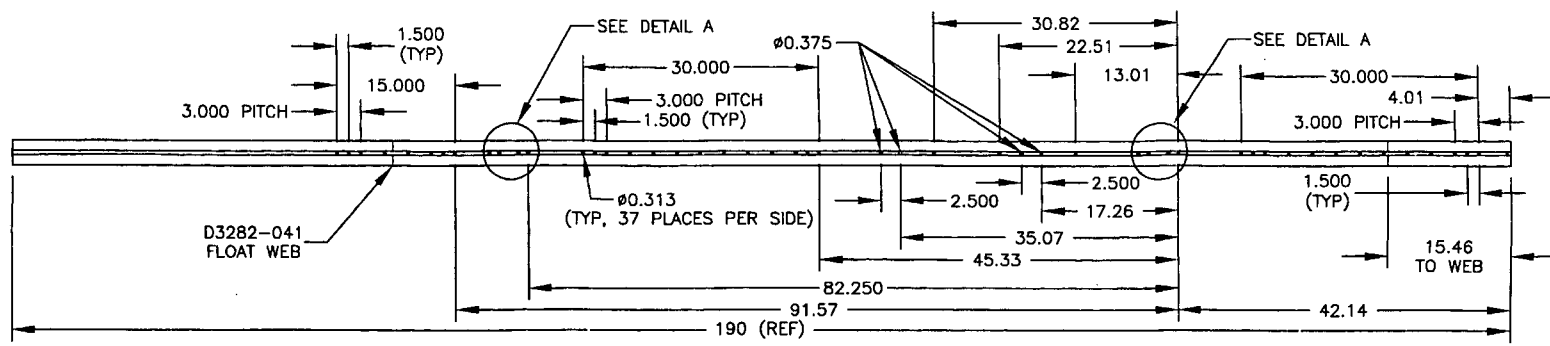
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

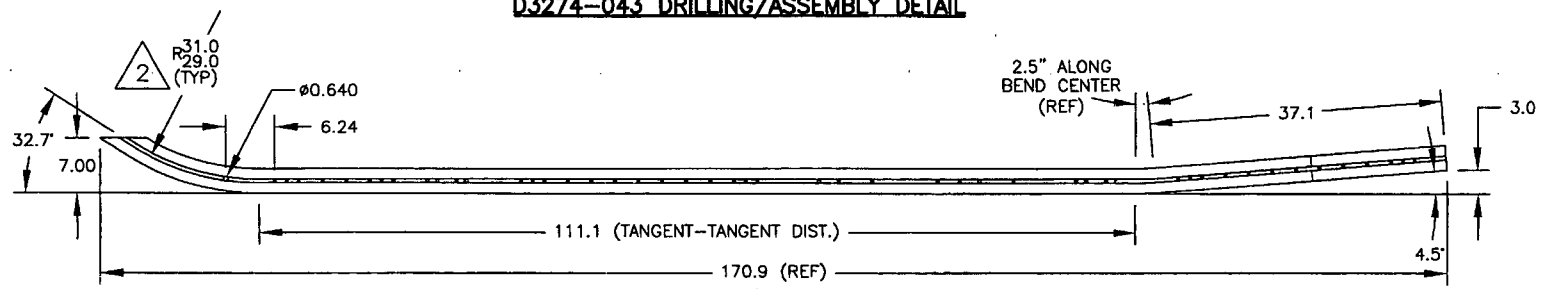
NOTE: Date & initial all entries

ULO 62767

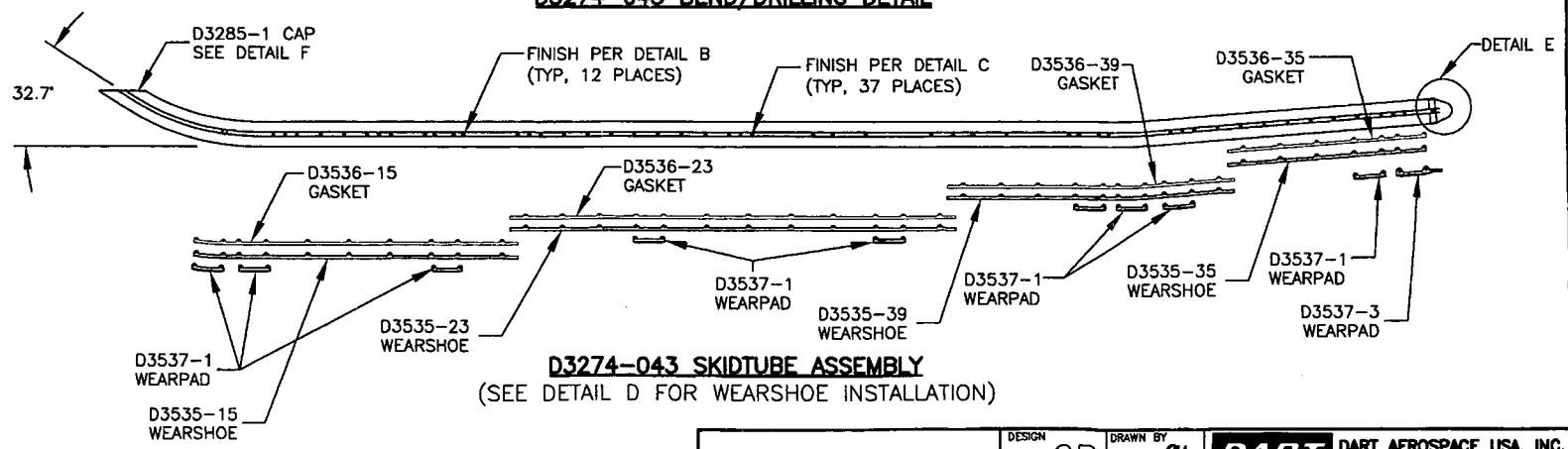
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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		CHECKED	APPROVED	DRAWING NO.	SHEET 3 OF 4
		DATE		D3274	
		06.12.19		TITLE	SCALE
				SKIDTUBE ASSEMBLY	1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

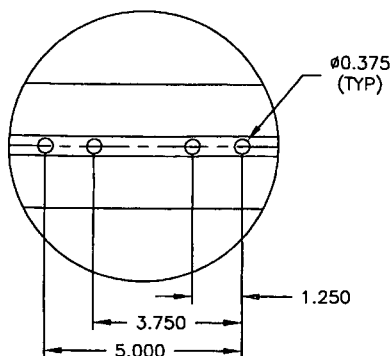
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

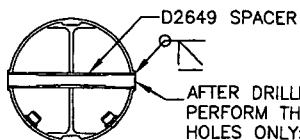
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A: DRILL DETAIL

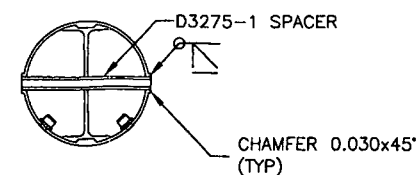


DETAIL B FOR 0.375 HOLES ONLY



- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C-BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY



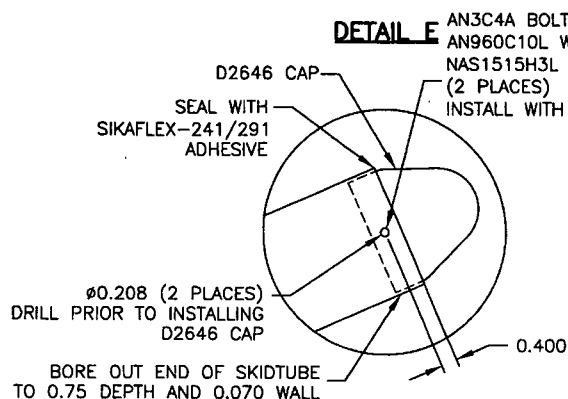
DETAIL D



- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E

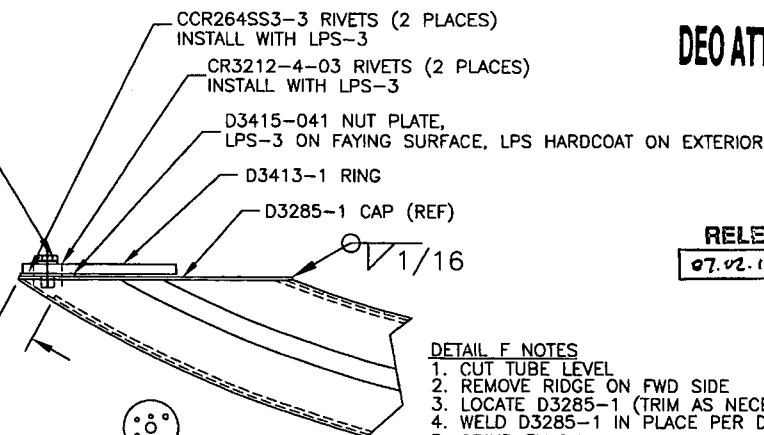


- AN4C5A BOLT (1)
AN960C416 WASHER (1)
INSTALL WITH SIKAFLEX-241/-291

1.0
REMOVE RIDGE
ON INSIDE OF
SKIDTUBE LEAVE
0.070 MIN.

ORIENTATION
OF D3415-041

DETAIL F: END FINISHING DETAIL



- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DEO ATTACHED

RELEASED
07.02.12

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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	#	APPROVED	#	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. 0 SHEET 4 OF 4 SCALE 1:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

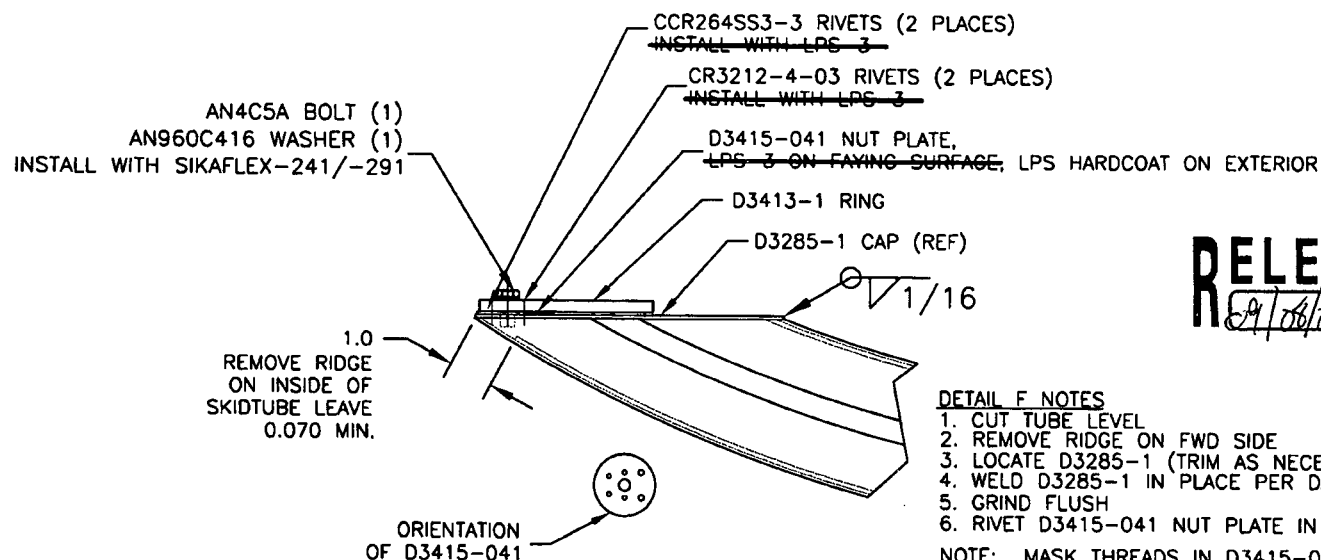
LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

w/o 62747

DETAIL F: END FINISHING DETAIL



RELEASED
09/06/23

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 241

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 62280
Part number: D206-442-541
Description: 206 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 10.09.30
Welder Barclay Elliott Date of Test Coupon 10.09.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld.